

Work Order ID 75134

October-17-11 3:44:25 PM

75134

Page 1

Item ID: D3276-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Baffle Assembly RH

Stop

NS2

Start Date: 17/10/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/10/11

Tooling: _____ Date: _____

Run Start

NR1

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr									
D3276	Rev B									
100			0.00							
100	FLOW WATER JET									
Waterjet		Memo	0.00							
FLOW CNC Waterjet		1-Cut as per Dwg D3276 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-								
(061.040)		Deburr if necessary								
110		QC2- Inspect parts off machine FAI/FAIB	0.00							
110		Memo	0.00							
QC										
Quality Control										
120		QC8- Inspect parts - second check	0.00							
120		Memo	0.00							
QC										
Quality Control										

Sulalip

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

0.00

SP 11/11/02

140

140

Brake NC

NC BRAKE

0.00

SP 11/11/02

Brake NC

Memo

0.00

Form as per Dwg D3276

150

150

QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

11-11-02 (4)

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Hand Finishing

4 BR 11-11-08

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

170

Powdercoat

Powder Coating

Memo

7-40

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-10

4XPM 11/11/08

180

QC3- Inspect Part Finish

0.00

180

QC

Quality Control

Memo

0.00

4 kit 4 30 uulog
counted

W/O:		WORK ORDER CHANGES					
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4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

190

Small Fab

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3276

200

200

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00 11/11/08

11/11/08 40
042

210

210

Packaging

Packaging

Identify as per dwg & Stock Location: 175

0.00

Memo

0.00

11/11/08 40

W/O:		WORK ORDER CHANGES					
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4

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							<i>W/11/09</i>
	Memo	0.00							<i>ME</i> 11-11-09

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

October-17-11 3:44:30 PM

Page 1

Work Order ID: 75134

75134

Parent Item: D3276-042

D3276-042

Parent Item Name: Baffle Assembly RH

Start Date: 17/10/2011

Required Date: 04/11/2011

Comments: IPP Rev:A New Issue 05-12-06 JLM
IPP Rev:B Now on Waterjet 06-09-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3276-3 *D3276-3* Decal		Manufactured	No			110	Each	13.0000	1	4		EJ 11/11/08	
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							ST045	13				3	
							56593	3				1	
							59694	10					
D2464 *D2464* 3/4 Seal		Manufactured	No			190	f	302.1000	2.25	9		EJ 11/11/08	
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							ST404	302.1				9	
							61878	302.1					
M6061T6S.040 *M6061T6S.040* 6061-T6 .040 Sheet		Purchased	No			190	sf	86.8000	1.0205	4.296842			
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							MAT021	86.8					
							113004	7.5					
							117653	79.3				117653	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD	Work Order:	75134
Description: Baffle	Part Number:	D3276-1
Inspection Dwg: D3276	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B</u>
Date:	(1-10-09)

Audited by: S

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	P/O D044-717-011	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>

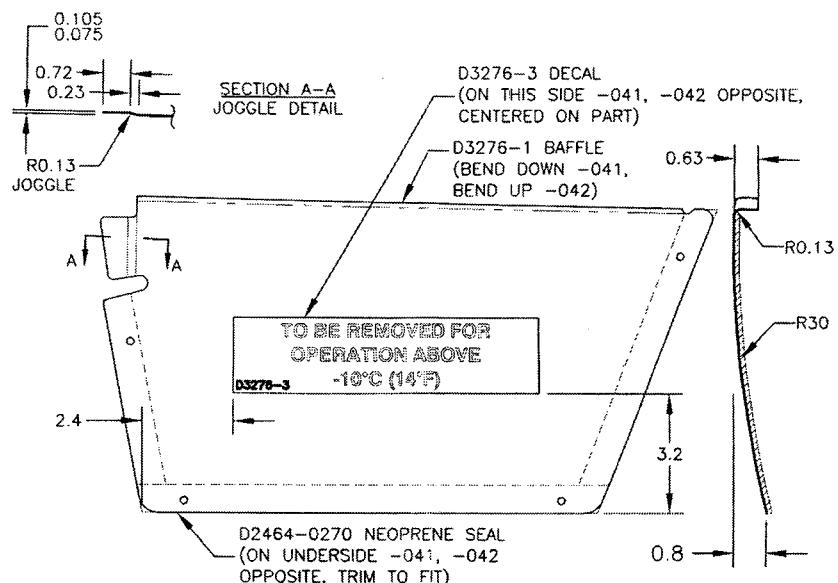
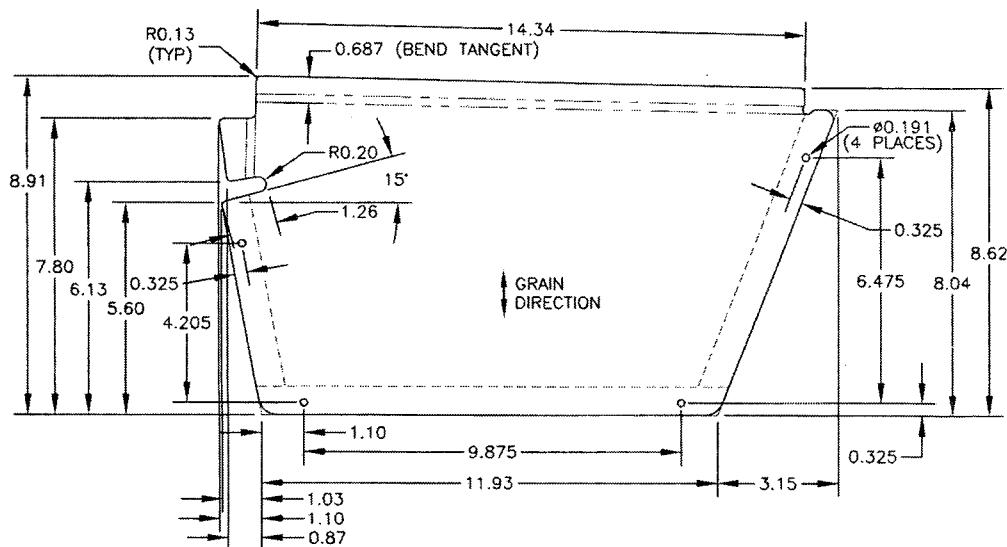
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI. 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO
ENGINEERING

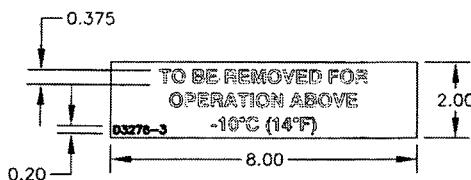
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 35134 M.L.S
11/10/17

RELEASED
05-02-02



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1. **What is the primary purpose of the study?**

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
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PERSON WITHOUT WRITTEN PERMISSION FROM

B	05.01.25	LABEL NOW -10°C; CURVE PART		
A	05.01.07	NEW ISSUE		
DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CP	CP			
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3276	SHEET 1 OF 1	
DATE	TITLE			SCALE
05.01.25	BAFFLE ASSEMBLY			1:3

W/O:		WORK ORDER CHANGES					
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